



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C45-3-11

Job Sheet 191776



Part No: C45-3-11

Job Qty: 8 pcs

Part Name: Actuator



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/8/19

Job Tracking No:

Due Date: 4/30/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: C45-3-11 rev.8 IPP REV:A 18.02.06 NEW ISSUE DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	NLX 2500SY - 1	8 pcs	4/30/19	4/30/19	0.00	1.60	NLX 2500SY - 1		
130	QC 2	8 pcs	4/30/19	4/30/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		



Container No: S165452



Part: C45-3-11

Job No: 191776

Serial No/Batch: S165452

Revision: 8

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/24/19

Plex 3/8/19 8:39 AM Dart.lajeunesse.marie

140 QC 8	8 pcs	4/30/19	0.00 0.00	QC 2 - 64	
				QC 2 - 65	
				QC 8 - 12	m/19/03/27
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
150 Packaging 3-2 - Stock - B4B	8 pcs	4/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	DAS 28 9-89
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	

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160 QC 21 - FG		8 pcs	4/30/19	0.00 0.00	Packaging 3 - 36 - B4B	
					QC 21 - FG - 21	DAS
					QC 21 - FG - 70	21
					QC 21 - SA - 53	1-53
Part Op 120 - MORI NLX 2500SY LATHE)1-Machine as per folio FB820 FOLIO REV: <u>AA</u> DWG REV: <u>8</u> Descriptions: 2-Debur 130 - (QC2- Inspect parts off machine FAI/FAIB) 140 - QC8- Inspect parts - second check) 150 - I(Identify as per dwg & Stock Location: _____)dentify and Stock 160 - (QC21- Final Inspection - Work Order Release)						
Job BOM						
Part / Item	Component Name	Quantity	Operation	Container		
M17-4-H900-R2.000	17-4 SS H900 Round Bar 2.000"	1.4400 ft (.18 ea)	120-NLX 2500SY - 1	M 128314		
Job Allocations						
Operation	Component Part	Required	Inventory	Allocated		
120-NLX 2500SY - 1	M17-4-H900-R2.000	1	19	0		
Part Specifications						
Specifications could not be found.						

32 1/2

Plex 3/8/19 8:39 AM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	191776
Description: <i>Actuator</i>		Part Number:	
Inspection Dwg: <i>C45-3-11</i>		Rev: <i>8</i>	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<i>19 x 45°</i>	<i>±.01 x .5°</i>	<i>19.0 x 45°</i>			<i>Vern L Pro</i>	
<i>Ø.390</i>	<i>±.005</i>	<i>.393</i>				
<i>.77</i>	<i>±.01</i>	<i>.775</i>				
<i>Ø.714</i>	<i>±.005</i>	<i>.710</i>				
<i>Ø.800</i>	<i>±.005</i>	<i>.798</i>				
<i>2.025</i>	<i>±.005</i>	<i>2.020</i>				
<i>.215</i>	<i>±.005</i>	<i>.215</i>				
<i>.381</i>	<i>±.005</i>	<i>.382</i>				
<i>.468</i>	<i>±.005</i>	<i>.469</i>				
<i>.188</i>	<i>±.005</i>	<i>.190</i>				
<i>.140</i>	<i>±.005</i>	<i>.140</i>				
<i>1.020</i>	<i>±.005</i>	<i>1.015</i>				
<i>.530</i>	<i>±.005</i>	<i>.526</i>				
<i>.265</i>	<i>±.005</i>	<i>.260</i>				
<i>.250</i>	<i>±.005</i>	<i>.251</i>				
<i>.06</i>	<i>±.01</i>	<i>.062</i>				
<i>Ø.624</i>	<i>+ .000 / - .004</i>	<i>.622</i>				
<i>Ø.684</i>	<i>+ .000 / - .004</i>	<i>.681</i>				
<i>Ø.800</i>	<i>±.005</i>	<i>.799</i>				
<i>Ø.680</i>	<i>+ .000 / - .004</i>	<i>.6775</i>				
<i>.317</i>	<i>±.005</i>	<i>.317</i>				
<i>.02 x 45°</i>	<i>±.01 x .5°</i>	<i>.02 x 45°</i>				
<i>.03 x 45°</i>	<i>±.01 x .5°</i>	<i>.03 x 45°</i>				
<i>.950</i>	<i>±.005</i>	<i>.950</i>				
<i>.850</i>	<i>±.005</i>	<i>.849</i>				
<i>1.285</i>	<i>±.005</i>	<i>1.284</i>				
<i>.620</i>	<i>±.005</i>	<i>.618</i>				
<i>.700</i>	<i>±.005</i>	<i>.697</i>				
<i>.063</i>	<i>±.005</i>	<i>.0615</i>				

Measured by: <i>J 19-03-23</i>	Checked by: <i>[Signature]</i>	QC Inspector:
Date: <i>19/03/27</i>	Date: <i>19/03/27</i>	Date:

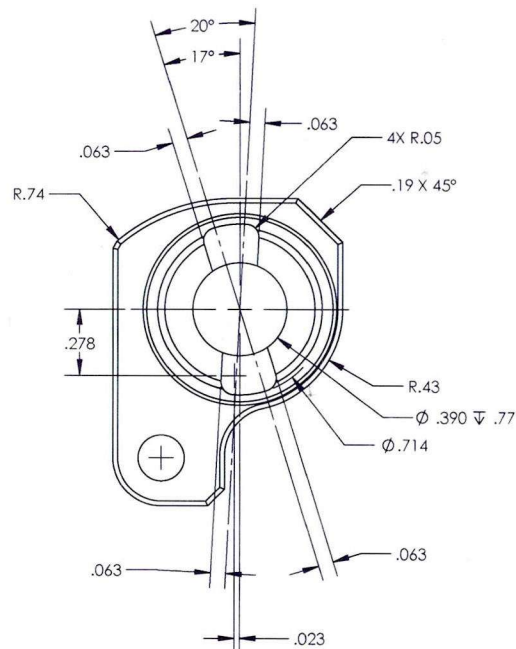
Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

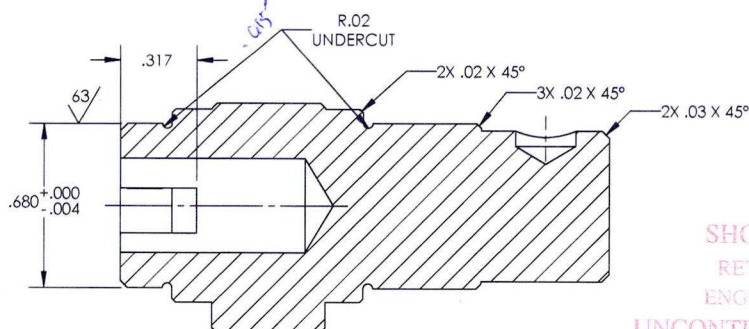
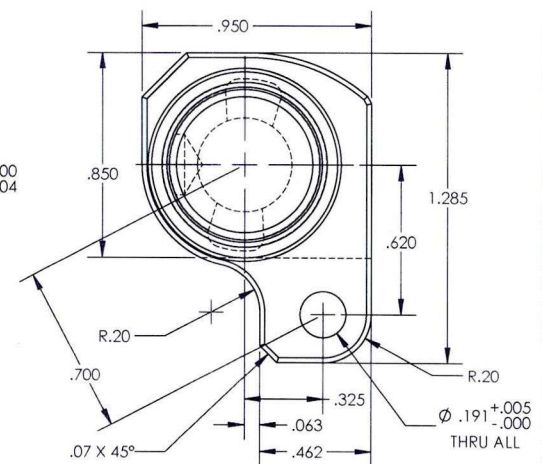
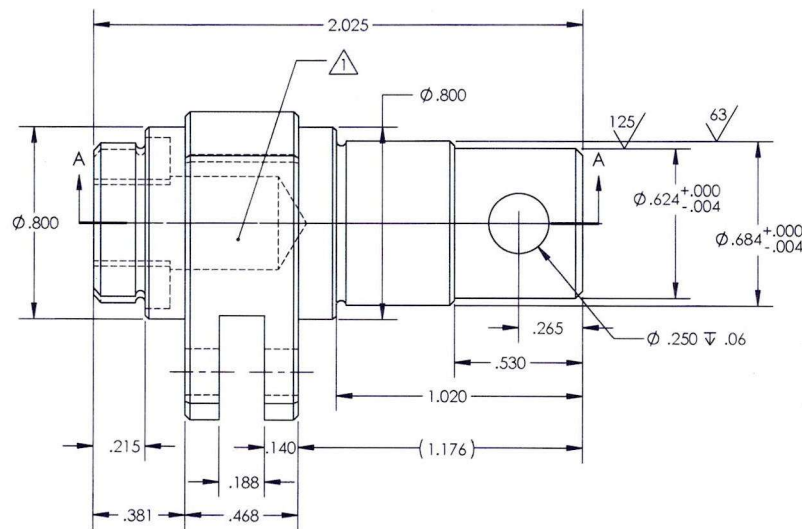
196
0955
295

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
6		AS DRAWN BY CANAM.	9/12/2012	RJC	
7		CHANGED HOLE FROM Ø.188 TO Ø.191	10/30/2012	JAG	
8	14-0128	CHD TITLE BLOCK WAS RED BARN IS DART. ADDED MACHINE ENGRAVE NOTE. CHD TOLERANCE ON NON-CRITICAL DIMENSIONS. CHD B/O INFO WAS 1 X 1-1/2 X 2-1/4 IS Ø2 X 2-1/8.	8/13/2014	DPD	RW



HIDDEN LINES
OMITTED FOR CLARITY



SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 19176013
190308

NOTE:

1. MACHINE ENGRAVE BATCH NUMBER.

DART AEROSPACE	
TITLE ACTUATOR	
DWG NO. C45-3-11	
REV 8	
MAT'L 17-4 S.S.	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 .XX ± .01 X ± .1	APPROVED <i>D. Med</i> TREAT FINISH SPEC 1. BREAK ALL SHARP EDGES .015 X 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING
SCALE 2:1	DATE 1/28/1998
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C45-3-11	1	ACTUATOR	17-4 S.S.	Ø2 X 2-1/8